

**Amendments to the Claims:**

This listing of claims will replace all prior versions and listings of claims in the application:

**Listing of Claims:**

1. (currently amended) A method comprising:  
placing prewritten discs, each characterized by servo tracks that are offset in relation to a common angular reference axis of each disc, a disc comprising servo pattern information written in relation to an angular reference axis around a motor hub, the prewritten discs rotated with respect to each other disposing the angular reference axes symmetrically around the motor hub; and  
biasing ~~the each~~ disc ~~against the motor hub in relation to~~ in a direction of the respective angular reference axis to concentrically align the servo tracks of a first disc of the prewritten discs with the servo tracks of a second disc of the prewritten discs.
2. (canceled)
3. (currently amended) The method of claim 1 wherein the biasing ~~the each~~ disc step comprises pressingly engaging against an edge of each ~~the disc in a direction along the reference axis.~~
4. (canceled)

5. (currently amended) The method of claim [[4]] 1 wherein the ~~first and second discs are biased~~ placing step comprises disposing the angular reference axes in different nonopposite directions.

6. (currently amended) The method of claim [[4]] 1 wherein the ~~first and second discs are biased~~ placing step comprises disposing the angular reference axes in substantially opposite directions.

7. (currently amended) The method of claim 1 wherein the ~~obtaining a disc~~ placing step comprises obtaining a disc wherein placing prewritten discs with each comprising an indicia associated with the angular reference axis comprises an indicia.

8. (currently amended) The method of claim [[1]] 7 wherein the ~~obtaining a disc step comprises obtaining a disc wherein the angular reference axis~~ placing step is characterized by an indicia comprising ~~comprises~~ a laser index mark.

9. (currently amended) The method of claim [[1]] 7 wherein the ~~obtaining a disc step comprises obtaining a disc wherein the angular reference axis~~ placing step comprises placing prewritten discs with each comprising a first indicia on one side of the prewritten disc associated with the angular reference axis and a second indicia associated with the angular reference axis and different than the first indicia on the other side of the prewritten disc.

10. (withdrawn) A disc stack comprising a disc biased against a motor hub in relation to a reference axis adapted for angularly orienting the disc for writing servo pattern information to the disc before the disc is biased against the motor hub.

11. (withdrawn) The disc stack of claim 10 wherein the reference axis is radially disposed in relation to the disc.

12. (withdrawn) The disc stack of claim 10 comprising a second disc biased against the motor hub in relation to a second reference axis adapted for angularly orienting the second disc for writing servo pattern information to the second disc before the second disc is biased against the motor hub.

13. (withdrawn) The disc stack of claim 12 wherein the first reference axis and the second reference axis are substantially parallel.

14. (withdrawn) The disc stack of claim 10 wherein the reference axis comprises an indicia.

15. (withdrawn) The disc stack of claim 10 wherein the reference axis comprises a laser index mark.

16. (withdrawn) The disc stack of claim 10 wherein the angular reference comprises a first indicia on one side of the disc and a second indicia on the other side of the disc.

17. (withdrawn) The disc stack of claim 16 wherein first indicia is different than the second indicia.

18. (withdrawn) A data storage device comprising a disc stack constructed by steps for biasing comprising:

placing a disc comprising servo pattern information written in relation to an angular reference axis around a motor hub; and  
biasing the disc against the motor hub in relation to the angular reference axis.

19. (withdrawn) The data storage device of claim 18 wherein the steps for biasing comprises:

obtaining a second disc comprising servo pattern information written in relation to a second angular reference axis;  
placing the second disc around the motor hub; and  
biasing the second disc against the motor hub in relation to the second angular reference axis.

20. (withdrawn) The data storage device of claim 19 wherein the steps for biasing is characterized by biasing the first disc and second disc in different directions.

21. (new) The method of claim 9 wherein the placing step is characterized by first and second indicia with each comprising a first line that is coextensive with the angular reference axis and a second line angularly disposed from the first line.

22. (new) The method of claim 21 wherein the placing step is characterized by first and second indicia with each comprising a third line angularly disposed from the first line.

23. (new) The method of claim 22 wherein the placing step is characterized by first and second indicia with each comprising second and third lines that are nonsymmetrically disposed from the first line.

24. (new) The method of claim 23 wherein the placing step is characterized by first and second indicia that are mirror images of each other.

25. (new) A disc stack comprising first and second discs that are each prewritten before stacking them with servo tracks that are offset with respect to a disc center and in relation to an angular reference axis, the discs being rotatable with respect to each other around a hub and subsequently fixable in rotation with the hub, wherein rotating the discs to align the angular reference axes and biasing the discs against the hub in a direction of the angular reference axes places the first disc concentrically disposed to the second disc and the servo tracks of the first disc concentrically disposed to the servo tracks of the second disc, and wherein rotating the discs to misalign the angular reference axes and biasing each disc against the hub in a direction of the respective angular reference axis places the first disc nonconcentrically disposed to the second disc and the servo tracks of the first disc concentrically disposed to the servo tracks of the second disc.

26. (new) The disc stack of claim 25 wherein at least one of the discs comprises an alignment mark incident with the angular reference axis.

27. (new) The disc stack of claim 26 wherein the disc comprises a first alignment mark on one side of the disc incident with the angular reference axis and a second alignment mark on an opposing side of the disc incident with the angular reference axis.

28. (new) The disc stack of claim 27 wherein the first and second alignment marks are different.

29. (new) The disc stack of claim 28 wherein the first and second alignment marks are mirror images of each other.

30. (new) A data storage device comprising:

a motor adapted for moving a disc stack in a data reading and writing relationship with a head; and  
a disc stack formed by steps for stacking two or more discs with prewritten servo information on the motor.

31. (new) The data storage device of claim 30 wherein the steps for stacking are characterized by writing the servo information to the discs in relation to a common angular reference.

32. (new) The data storage device of claim 31 wherein the steps for stacking are characterized by placing discs with prewritten servo information around the motor with the plurality of angular references of each disc symmetrically distributed around the motor.

33. (new) The data storage device of claim 32 wherein the steps for stacking are characterized by biasing the discs in a direction of the respective angular references of each disc.